

Amendments to the Specification:

Please insert the following new paragraph on page 1, between lines 2 and 3, directly following the title of the invention:

-- Cross Reference to Related Application

This application claims priority of German patent application no. 102 43 520.0, filed September 19, 2002, the entire content of which is incorporated herein by reference. --

The paragraph starting at page 1, line 18, is amended and now reads as follows:

-- In the known method, a blank of the cylinder housing is first cast which is provided only with the flow channels enclosed in the cylinder wall so that the blank cylinder body can be cast with a high degree of efficiency and a savings of manufacturing costs. In a second method step for making the cylinder, a control window is machined in for each transfer channel with a non-contact machining process, for example, an electric discharge machining process. The known method assumes that a precise machining in the formation of the control window in the cylinder wall is only possible with a non-contact machining process. In the known non-contact machining process of the control windows, a work tool is introduced into the cast blank cylinder body and is brought into position at the wall section of the cylinder wall where the control window is intended to be cut out in the cylinder wall for connection [[to]] with the still hidden

transfer channel. --

The paragraph starting at page 7, line 30, is amended and now reads as follows:

-- FIG. 4 shows the side-milling cutter 7 in the machining position in the cylinder wall 2. The cutter head 7 is moved up to a cut [[into]] in the cylinder wall 2 in correspondence to the width B of the control window 5 in the peripheral direction of the cylinder. As soon as the cut in the cylinder wall corresponds to the width B, the thrust movement of the machine tool is stopped and the cutter head 7 is moved out of the workpiece to permit an exchange of the work tool. A burr having a comma-shaped cross section remains on the edge of the control window 5 because of the rotating primary movement of the work tool during machining with the cutter head 7. The burr is removed in the subsequent machining phase of the multi-stage machining process for forming the control window. This can be carried out without contact via erosion, laser action or like machining operation. Preferably, and after the machining with the rotating cutter head 7, a furrowing tool is clamped to the work spindle 6 and is moved by the work spindle into the work position in the interior of the cylinder housing. The furrowing work tool is to be guided along a straight line and can be a broaching or reaming tool. --